

Express Mail No. EV 329 805 325 US
Attorney Docket No. 3409/82659

PATENT APPLICATION

IN THE UNITED STATES PATENT AND TRADEMARK OFFICE

INVENTORS: EDWARD L. COTE
 ANDREW D. WENZEL
 LANCE E. AGNESS

INVENTION: METHOD FOR TREATING BRASS

Barnes & Thornburg
600 One Summit Square
Fort Wayne, Indiana 46802
(260) 423-9440

SPECIFICATION

To All Whom It May Concern:

Be it known that Edward L. Cote, Andrew D. Wenzel, and Lance E. Agness, citizens of the United States of America, residing at 48751 Thornbury, Novi, Michigan 48374; 1412 Manor Drive, Mount Horeb, Wisconsin 53572; and 909 N 100 E., Wabash, Indiana 46992; respectively, have invented certain new and useful improvements in a

METHOD FOR TREATING BRASS

of which the following is a specification.

METHOD FOR TREATING BRASS

RELATED APPLICATIONS

The present application is related to and claims priority as a Continuation-in-Part to U.S. Patent Application Serial No. 10/238,377, filed on September 10, 2002,
5 entitled METHOD FOR TREATING BRASS, which is a Continuation-in-Part of U.S. Patent Application Serial No. 09/652,799, filed on August 31, 2000, now U.S. Patent No. 6,447,616, entitled METHOD FOR TREATING BRASS. The present application is also related to and claims priority as a Continuation-in-Part to United States Patent Application Serial No. 10/217,190, filed August 12, 2002, entitled METHOD OF
10 TREATING BRASS, which is a Continuation-in-Part to United States Patent Application Serial No. 09/795,551, filed February 28, 2001, now United States Patent No. 6,432,210, entitled METHOD OF TREATING BRASS, which is a Continuation-in-Part to United States Patent Application Serial No. 09/652,799, filed on August 31, 2000, now U.S. Patent No. 6,447,616, entitled METHOD FOR TREATING BRASS. To the extent not
15 included below, the subject matter disclosed in those applications is hereby expressly incorporated into the present application.

TECHNICAL FIELD

The present invention relates to a process for treating brass. More particularly, the present invention is directed to a process of removing lead from the
20 surface of brass fixtures.

BACKGROUND ART AND SUMMARY

Brass is an alloy composed principally of copper, tin zinc and lead. The amount of lead added to brass affects its strength, workability and machinability of the

final alloy. Brass has been widely used for plumbing fittings, waterworks valves and fittings, bronze alloys and a host of other applications. Perhaps the most widespread application of brass is its use in the manufacture of faucets, valves, fittings, water meters, and related products intended for use in delivering potable water to and within commercial or residential sites. For such uses, the amount of lead that is required to affect the desired strength machinability of the brass causes concerns with the leachability of the lead into the environment where such faucets, valves, fittings and related products are used.

Lead exhibits a relatively low solubility in solid solution in brass alloys due to the atomic size of lead atoms which is larger than copper or zinc. The low solubility of lead in brass alloys causes the lead to precipitate in lead-rich regions dispersed throughout brass alloys. The tendency toward precipitation is particularly notable near the surface of brass articles. In addition to improving the machinability of brass adjacent to the surface, the precipitation of lead near the surface increases the tendency of lead present on the surface to leach into water.

Recent standards have significantly limited the acceptable amount of lead that can be leached from brass faucets, valves, fittings and related products. One such example is the Safe Drinking Water Act, amended in 1988, to limit lead in solders and fluxes to 0.2 percent and to limit lead in public water supply pipes and fittings to 8 percent.

Similarly, efforts have been underway to limit the amount of lead found in food or water. California, for example, has promulgated regulations limiting lead exposure of an individual to less than 0.5 micrograms per day. On the Federal level, the EPA, in 1991, restructured the standard of lead in drinking water from 50 parts per billion to 15 parts per billion.

While the amount of lead that can be leached from brass plumbing components is generally low, it is nonetheless possible that the amount of lead that can be

leached from such components may exceed current or planned standards. It has been proposed that current standards be made even more stringent so that lead is omitted totally from brass alloys or that brass articles be treated so that minimum quantities of lead may be leached from such articles.

5 The present disclosure provides a simple, relatively efficient process for treating brass which removes leachable lead therefrom.

 An illustrative disclosure provides a method of treating brass articles to reduce leachable lead therein. The method comprises the steps of, first contacting a brass article with a primary treatment solution to reduce leachable lead therein. The primary
10 treatment solution comprises an aqueous caustic solution containing a chelating agent. The next step is contacting the brass article with a post-treatment solution after being contacted with the primary treatment solution. The post-treatment solution comprises an aqueous solution containing an azole.

 In the above and other illustrative embodiments, the method of treating
15 brass articles may also provide: the chelating agent being selected from the group consisting of phosphonic acids, aminopolycarboxylic acids and mixtures thereof; the chelating agent being selected from the group consisting of ethylenediaminetetraacetic acid, N-hydroxyethylethylene-diaminetriacetic acid, diethylenetriaminepentaacetic acid and mixtures thereof; the caustic solution including a caustic component selected from
20 the group consisting of an alkali metal hydroxide, an alkali metal carbonate, an alkali metal phosphate and mixtures thereof; the brass article being sonicated during contact with the primary treatment solution; the brass article being contacted with a pretreatment solution prior to being contacted with the primary treatment solution, said pretreatment solution comprising an aqueous solution containing a sodium persulfate; the brass article
25 being sonicated during contact with the pretreatment solution; the post-treatment solution being at a temperature of about 120 degrees Fahrenheit; the azole being selected from a group consisting of mercaptobezothiazole, benzotriazoles, and tolytriazole.

Another illustrative embodiment of the present invention also provides a method of treating brass articles to reduce leachable lead therein. This embodiment comprises the step of contacting a brass article with a treatment solution comprising an aqueous solution containing an azole.

5 In the above and other illustrative embodiments, the method of treating brass articles may also provide: the treatment solution being at a temperature of about 120 degrees Fahrenheit; the azole being selected from a group consisting of mercaptobezothiazole, benzotriazoles, and tolytriazole; the treatment being followed by a 70 degree Fahrenheit water rinse; the 70 degree Fahrenheit water rinse being followed by
10 a 150 degree Fahrenheit ultrasonic water rinse; and the 150 degree Fahrenheit ultrasonic water rinse being followed by an azole rinse at 120 degrees Fahrenheit.

Additionally, in the above and other embodiments, the method of treating brass articles may provide: subsequent to contacting a brass article with a treatment solution comprising an aqueous solution containing the azole, the brass article being
15 contacted with water; the water being at a temperature of about 80 to about 140 degrees Fahrenheit; contacting the brass article again with water having a temperature of about 80 to about 140 degrees Fahrenheit; the water being reverse osmosis water; contacting the brass article with an about 0.5 to about 5 percent benzotriazole solution; the about 0.5 to about 5 percent benzotriazole solution being at a temperature of about 80 to about 140
20 degrees Fahrenheit; contacting the brass article with the about 0.5 to about 5 percent benzotriazole solution for about 3 to about 15 minutes; contacting the brass article with the about 0.5 to about 5 percent benzotriazole solution subsequent to a water rinse; contacting the brass article again by water subsequent to contacting the brass article with the about 0.5 to about 5 percent benzotriazole solution.

25 Additional features and advantages of the method of treating brass articles will become apparent to those skilled in the art upon consideration of the following

detailed description of the illustrated embodiment exemplifying the best mode of carrying out the method of treating brass articles as presently perceived.

DETAILED DESCRIPTION

5 The present disclosure is directed to a process of removing lead from brass and bronze articles. The process can be used to treat a variety of brass fixtures including faucets, valves, fittings and other brass and bronze articles.

The process of the present invention involves contacting brass articles to be treated with a high pH solution containing a chelating agent. The pH of the solution should be at least about 6 to 10, and even above 10.

10 According to theory, chelating agents possess acid-base characteristics and chelation is an equilibrium reaction. Accordingly, during the course of the present invention, it has been found that using high pH solutions in conjunction with chelating agents improved the removal of lead from brass articles.

15 Accordingly, an amount of caustic should be included in the treatment solution which is sufficient to raise the pH of the solution to at least about 6 to 10, and preferably above 10.

20 A number of chelating agents including phosphonic acids and aminopolycarboxylic acids can be used according to the present invention. Particularly suitable chelating agents include ethylenediaminetetraacetic acid (EDTA), N-hydroxyethylethylene-diaminetriacetic acid (HEDTA), and diethylenetriaminepentaacetic acid (DTPA), with ethylenediaminetetraacetic acid (EDTA) being particularly suitable for purposes of the present invention.

25 The pH of the treatment solution can be adjusted by adding a caustic material such as an alkali metal hydroxide, an alkali metal carbonate, or an alkali metal phosphate. Alkali metal hydroxides are particularly useful, with sodium hydroxide being suitable for purposes of the present invention.

The primary treatment solution thus comprises an aqueous solution of a caustic and chelating agent. After the primary treatment bath, treated brass articles should be subjected to a treatment rinse using water. For optimal rinsing, parts may be subjected to ultrasonics at 25 kHz to 40 kHz, or the bath can be agitated or caused to flow or circulate.

In addition to the primary treatment solution which is also referred to herein as the primary treatment bath, an optional pretreatment solution which comprises an aqueous bath containing an organic carboxylic acid and an inorganic per salt such as ammonium persulfate, sodium persulfate, potassium persulfate, or sodium perborate can be used according to the present invention.

A typical pretreatment bath useful for purposes of the present invention comprises an aqueous solution containing citric acid and sodium persulfate.

When a pretreatment bath is used, treated brass articles should be subjected to a pretreatment rinse using water.

In addition to the optional pretreatment bath, brass articles processed by the present invention can also be subjected to a post-treatment bath.

Brass articles that are treated with a caustic such as sodium hydroxide have an appearance that may not be acceptable in the brass fixture industry. The uneven brownish-black appearance produced during treatment in the primary treatment bath is believed to be due to a copper oxide layer. Although this discoloration may not be a factor in treating brass articles whose aesthetic appearance is unimportant, the appearance of discoloration on other brass articles such as faucets can be important.

A post-treatment bath containing either thiourea or sodium persulfate was determined to reduce the metal oxide present on the brass parts that were darkened by the primary treatment bath. A thiourea or sodium persulfate post-treatment bath containing thiourea and ammonium chloride or sodium persulfate, respectively, having a near neutral pH of about 6 or 3, respectively, was found to be particularly useful.

In an alternative embodiment, an application of hydrogen peroxide can be used either as a pre- or post-treatment to the caustic/EDTA treatment. In this embodiment, the use of hydrogen peroxide, as a treatment bath, for example, can assist to produce an evenly colored part appearance. It is appreciated that in one embodiment the hydrogen peroxide may be used in lieu of the persulfate.

In another alternative embodiment, rinses with a solution of benzotriazole and water in place of sodium persulfate aid in the reduction of leachable lead.

Benzotriazoles are anticorrosion agents. It is contemplated that azoles, such as mercaptobezothiazole, benzotriazoles, and tolytriazole, could be used herein.

Illustratively, the azoles will reduce the leachability of metals into potable water. After the primary treatment baths, parts are rinsed with 80-140 degrees Fahrenheit reverse osmosis water (twice) and then dipped in a bath of 0.5-5 percent benzotriazole solution at 80-140 degrees Fahrenheit for 3-15 minutes. The benzotriazole solution will be followed by an additional reverse osmosis water rinse.

The primary treatment bath can contain about 1 to about 10 weight percent of one of the chelating agents mentioned above and about 1 to about 20 weight percent of one of the caustic components mentioned above. An illustrative treatment bath referred to in the examples below includes about 1 weight percent of EDTA and about 5 weight percent sodium hydroxide. The pH of the primary treatment bath should be at least about 10 to about 14.

It is appreciated that the brass articles to be treated can be contacted by the primary treatment bath by dipping, immersing, continuous spraying or any procedure which results in contacting the articles with the bath. When the brass articles are dipped or immersed into the primary treatment bath they should be in contact with the bath for about 10 to about 60 minutes, and ideally for about 15 to about 40 minutes. Treatment times of about 30 minutes were found to be generally suitable for purposes of the present invention.

When dipped or immersed in a primary treatment bath, the brass articles can be sonicated at about 25 kHz to about 40 kHz. In addition, or alternatively, the primary treatment bath can be agitated or caused to flow or circulate.

5 An optional pretreatment bath can be used in conjunction with the primary treatment bath. A suitable pretreatment bath can include about 1 to about 30 weight percent of an organic carboxylic acid and about 1 to about 30 weight percent of an inorganic per-salt. An illustrative pretreatment bath referred to in the examples above includes about 10 weight percent citric acid and about 10 weight percent of sodium persulfate. The brass articles can be contacted with the pretreatment bath in the same
10 manner as they are contacted with the primary treatment bath. The brass articles can be contacted with the pretreatment bath for about 0.01 to about five minutes.

When dipped or immersed in a pretreatment bath, the bath can be agitated or caused to flow or circulate. The brass articles should be rinsed after treatment in the pretreatment bath and before treatment in the primary treatment bath in order to prevent
15 contamination of the primary treatment bath.

Treatment of the brass articles in the primary treatment bath and the optional pretreatment bath will effectively remove leachable lead therefrom. If the resulting surface appearance of the brass articles is unacceptably oxidized, the parts can be further treated by contacting them in a post-treatment bath that contains about 5 to
20 about 10 weight percent of thiourea and about 1 to about 10 weight percent of ammonium chloride, or the thiourea and about 1 to 2 volume percent of sodium persulfate. Alternatively, an about 0.5 to about 5 percent sodium persulfate bath can be used.

The following examples are presented to illustrate, but not limit, the invention as variations thereon will become obvious to those skilled in the art. In the
25 examples and throughout percentages are by weight unless otherwise indicated.

EXAMPLE 1

In this example, brass couplings and 1/2 inch brass check valves were treated with a caustic/EDTA bath and a caustic pretreatment bath to determine the effectiveness of the baths.

5 The brass parts were pretreated for 30 seconds in an aqueous solution containing 10 percent by weight of citric acid and 10 percent by weight of sodium persulfate. After the pretreatment bath, the parts were rinsed in deionized water.

10 The pretreated and rinsed brass parts were dipped for 15 minutes in either a caustic bath containing 5 percent by weight of sodium hydroxide or in a caustic/EDTA bath containing 5 percent by weight of sodium hydroxide and 1 percent by weight of EDTA. The parts were sonicated at either 25 kHz or 40 kHz during treatment. The treated parts were subsequently rinsed in deionized water.

15 It was determined that the caustic treatment bath that contained 1 percent by weight EDTA successfully extracted lead from the brass parts without leaving a metal oxide residue (as was the case for some coupons treated in the caustic bath). Generally, the mass of lead removed in the caustic bath was slightly higher than the caustic/EDTA bath. However, there was an increase in copper and zinc removed which raised concerns regarding treatment of used bath solutions. Also, the caustic bath had a tendency of depositing metal oxides on treated parts.

20 Lead leaching test showed that parts sonicated at 25 kHz released 30 percent more lead than parts sonicated at 40 kHz. It was determined that at 40 kHz a smaller amplitude sound wave is generated, subsequently causing smaller cavitation bubbles to contact the surface of the parts. The smaller bubbles are capable of navigating the crevasses of complex brass surfaces, resulting in a more uniform surface lead removal. At 25 kHz the brass surface is more vigorously attacked, but not in a uniform manner.

25

All treated couplings, regardless of treatment protocol, passed the leach test of 5 ppb. The normalized lead concentration for each coupling result (average of three) was below 1 ppb.

Pretreatment of the parts with the caustic solution caused pitting of the surface brass and an increase in surface area. Total lead released to the caustic/EDTA treatment was slightly elevated (approximately 7 percent) for pretreated parts in comparison to untreated parts at 40 kHz. The untreated couplings showed a marked increase in soluble lead (ranging from 30 percent - 110 percent) over the pretreated parts during lead leaching testing.

EXAMPLE 2

Brass articles that are treated with sodium hydroxide have an appearance that is not acceptable in the brass fixture industry. The uneven brownish-black appearance produced during treatment in the primary treatment bath is believed to be a copper oxide layer. In this example, formulations for a post-treatment bath that would restore the brass appearance without compromising the leachable lead content that was reduced by the primary treatment bath were evaluated.

Initially, a thiourea post-treatment bath that contained acid components (sulfamic acid and hydrogen chloride) was tested. This bath composition was found to create excessive effervescing of the brass articles due to hydrogen gas that evolved as the acid dissolved the brass, exposing a fresh layer of lead. Such newly exposed lead was determined to be susceptible of further leaching. Accordingly, it was decided to remove the acid components from the post-treatment bath.

As a result of experimental testing, a post-treatment bath containing about 5 percent thiourea and 6.25 percent ammonium chloride which had a pH of about 6.0 was determined to reduce the metal oxide layer present on brass articles. Moreover, it was determined that the thiourea treatment was not aggressive enough to cause a significant

amount of copper to be removed and, thus, expose fresh lead on the surface of the articles.

Still further, testing with a 1 to 2 volume percent of sodium persulfate bath with a pH of about 2 to 6 did produce parts with good appearance, and did not adversely affect the lead leaching, making this bath suitable for use on a production scale.

EXAMPLE 3

Having established that smaller brass parts could be effectively pretreated with an aqueous solution containing citric acid and sodium persulfate, followed by treatment in a caustic solution containing EDTA while subjected to 40 kHz ultrasonics, further testing was conducted to determine whether this treatment scheme could be used to treat an array of brass articles, including larger brass parts.

In this example, eight different articles having a total combined weight of about 30.5 pounds were treated to mimic conditions for a full scale treatment operation. Information on each article is provided in Table 1.

TABLE 1

Part Letter	Part Name	Weight (lbs.)	Internal Volume (liters)
A	3/4" Key Meter Valve	1.7	0.023
B	3/4" Ball Meter Valve	2.0	0.024
C	3/4" Check Valve	1.3	0.051
D	1" Ball Meter Valve	3.1	0.032
E	3/4" Ball Valve Curb Stop	1.9	0.022
F	1" Pack Joint Nut	2.7	0.088
G	2" Angle Meter Valve	9.4	0.22
H	2" Ball Valve Curb Stop	8.4	0.25

In this example, all the parts were pretreated for 30 seconds in a 10 percent citric acid and 10 percent sodium persulfate bath. Following pretreatment, the parts were rinsed in four groups (A B C; D E F; G and H). Each group was rinsed in a separate three liter deionized water bath.

Following a pretreatment rinse, all eight parts were treated consecutively (A through H) in a 16.2 liter caustic/EDTA bath (5 percent NaOH, 1 percent EDTA) for 30 minutes each. The parts were sonicated at 40 kHz during treatment. Following treatment, each part was rinsed in a separate three liter deionized water bath.

The effectiveness of treatment was determined from measurements of the release of copper, lead and zinc to both the treatment and rinse baths calculated as an average with treatment bath age. These results of the loss of lead are shown in Table 2.

TABLE 2

Part	Treatment Bath (mg)			Rinse Bath (mg)		
	Pb/part	Pb/lb Actual	Pb/lb Average	Pb/part	Pb/lb Actual	Pb/lb Average
A	145.90	85.83	85.83	0.27	0.16	0.23
B	134.14	67.07	75.69	0.31	0.16	0.23
C	263.25	202.50	108.66	1.95	1.50	0.23
D	228.74	73.79	95.31	1.74	0.56	0.23
E	217.73	114.59	98.98	1.56	0.82	0.23
F	258.23	95.64	98.27	3.15	1.17	0.23
G	362.23	38.54	72.86	6.36	0.68	0.23
H	903.47	107.56	82.42	16.69	1.99	0.23

Table 3 lists the average loss of lead, copper and zinc.

TABLE 3

Metal	Average Metal Removed (mg. metal/lb. brass)
Lead	82.4
Copper	13.1
Zinc	2.7

5 The results of this example show that the treatment bath experienced only minor degradation over time. Generally, the average lead removal per pound brass treated stayed relatively constant and total lead removal tended to increase with increased weight and internal volume. When the weight of each part is factored into the removal efficiency, the lead removed per pound decreases.

All eight parts easily passed the leach test target limit of 5 ppb (normalized) lead. In fact, all parts, with the exception of the two-inch Angle Meter Valve, leached lead below 1 ppb during a 17 day leach test conducted at pH 10.

The results of this example proved that the treatment protocol developed for smaller brass parts was applicable to an array of parts, ranging in size and shape.

From tests performed, it was determined that 12000 lbs. of brass parts can be treated on a daily basis using 234 lbs. of caustic (NaOH), 47 lbs. of sodium EDTA, 87 lbs. of citric acid and 87 lbs. of sodium persulfate.

EXAMPLE 4

In this example nine two-inch check valves weighing 9.1 lbs. each were consecutively pretreated for 30 seconds in a single five liter aqueous bath containing 10 percent citric acid, 10 percent sodium persulfate. Following pretreatment, each check valve was rinsed in a separate three liter bath of deionized water.

Each check valve was then consecutively treated in a 16.2 liter caustic/EDTA bath (5 percent NaOH, 1 percent EDTA) for the following time increments 20, 40, 60, 60, 40, 20, 40, 60, and 20 minutes while undergoing sonication at 40 kHz. Following treatment, each check valve was rinsed in a separate three liter deionized water bath for five minutes.

Total metal removed was calculated from samples of the treatment bath and subsequent rinse bath. These values which are given as mg. metal/lb. brass are listed in Table 4.

TABLE 4

Treatment Duration (min)	Lead	Copper	Zinc
20	64.5	10.7	2.2
40	92.7	12.6	2.9
60	77.9	12.1	2.7

The average mass of metal removed per pound of brass (mg./lb.) treated was comparable to the average in Example 3 above, as shown in Table 5.

TABLE 5

Metal	Array of Parts (Ex. 3)	2" Check Valves	percent Increase
Lead	82.4	92.7	12%
Copper	13.1	12.6	-4%
Zinc	2.7	2.9	7%

5 As can be seen, the average mass of metal removed per pound of brass treated was comparable to the average calculated from the array of parts in Example 3. Although the majority of the two-inch check valves treated for 20 or 60 minutes did not pass the leach test for lead, the check valves treated for 40 minutes were either below the target limit of 5 ppb (normalized) lead or within the range of the target limit. Parts
10 treated for 20 or 60 minutes were consistently above the limit.

Upon review of bath kinetics, it was determined that the bath was spent after approximately three check valves were treated. After treatment of three check valves the copper concentration approached its maximum of 25 mg/L in solution, above which metal oxide plating occurred. It was determined that an increase in EDTA for

check valves treated for 40 minutes would likely produce parts able to pass regulatory standards for lead.

EXAMPLE 5

In this example, a 1 < inch check valve weighing 6.9 lbs. was pretreated for 30 seconds in a five liter aqueous bath containing 10 percent citric acid, 10 percent sodium persulfate. Following pretreatment, the check valve was rinsed in a three liter bath of deionized water.

The check valve was then treated in a 16.2 liter caustic/EDTA bath (5 percent NaOH, 1 percent EDTA) for 30 minutes while undergoing sonication at 40 kHz. Following treatment, the check valve was rinsed in a three liter deionized water bath for five minutes.

Total metal removed was calculated from samples of the treatment bath and subsequent rinse bath. These values which are given as mg. metal/lb. brass are listed in Table 6.

TABLE 6

Metal	lbs. Metal/lbs. Brass Treated
Lead	79.2
Copper	18.0
Zinc	0.1

The lead removal in this example is comparable to the average lead removal calculated in Example 3 above. The mass of the copper increased and the mass of the zinc decreased in comparison to the results in Example 3.

The leach test results show that the 1 < inch check valve easily passed the target leach test for lead at pH 10.

EXAMPLE 6

In this example, parts were treated using various azole formulations. Six
5 treatment processes were performed on brass couplings. Each coupling was first
subjected to pretreatment bath. The pretreatment bath contained about 4-6 percent citric
acid and 4-6 percent sodium persulfate. The pretreatment was followed by a water rinse.
The couplings were then subject to three primary bath treatments, each containing about
4-6 percent sodium hydroxide and about 2-4 percent EDTA. This was followed by four
10 water rinses. The couplings were treated for about three minutes in the first bath and
about five minutes in each subsequent bath. The couplings were subjected to heat,
sonics, and agitation during the primary bath treatment.

The first test created the control wherein three couplings were subjected
only to the above pretreatment and primary treatment baths. The second test also
15 included three couplings being treated using the above pretreatment and primary
treatment baths. These couplings, however, were also treated in a container of about a 45
percent benzotriazole and 55 percent isopropanol alcohol solution, also known by its
trade name, Cobratech® 45I, manufactured by PMC Specialties Group. The solution was
maintained at a temperature of about 120 degrees Fahrenheit before the couplings were
20 dried. The third test included three couplings being treated using the pretreatment and
primary treatment baths. The couplings were then treated in a container of an about 0.1
percent solution of dipropylene glycol monomethyl ether, also known by its trade name,
Cortec® VCI-316. The solution was maintained at a temperature of about 120 degrees
Fahrenheit. The couplings were then dried. The fourth test included treating three
25 couplings in the pretreatment and primary treatment baths, each for five minutes. The
four water rinses of the primary treatment, however, were replaced with a 70 degree

Fahrenheit water rinse, a 150 degree Fahrenheit ultrasonic water rinse, and then a 120 degree Fahrenheit benzotriazole/isopropyl alcohol (Cobratech® 45I) rinse. The fifth test included treating three couplings using the process previously described in the fourth test. The four water rinses were, too, replaced by a 70 degree Fahrenheit water rinse, a 150 degree Fahrenheit ultrasonic water rinse, and a 120 degree Fahrenheit dipropylene glycol monomethyl ether (Cortec® VCI-316) rinse. The sixth test included treating three couplings also using the same process as used in the fourth test. The water rinses, however, were again replaced by a 70 degree Fahrenheit water rinse and a 150 degree Fahrenheit ultrasonic water rinse.

After treatment, each of the couplings was leach tested using the ANSI/NSF 61 Section 8 Leach Test Protocol, producing the results shown in Table 7.

TABLE 7

Day 17 Normalized Results				
Test	PH	Result	Appearance	Variation
1	5	3.46	Good	8.878
1	10	0.212	Good	
2	5	2.802	Good	4.097
2	10	0.074	Good	
3	5	2.030	Good	3.35
3	10	0.23	Good	
4	5	1.045	Bad	0.501
4	10	0.667	Bad	
5	5	1.167	Bad	0.741
5	10	0.785	Bad	
6	5	2.877	Bad	1.232
6	10	1.056	Bad	

This test demonstrated that the inclusion of azoles as part of the rinse sequence of the process (Tests 2 through 5) provided the desired lower leach test results when compared to parts treated without the rinse (Test 1 and 6).

EXAMPLE 7

5 Another test was conducted using the Cobratech® 45I formulation. Brass valves subjected to a pretreatment bath containing a 4-6 percent citric acid and 4-6 percent sodium persulfate solution. The pretreatment was followed by a water rinse. The valves were then subject to three primary baths, each containing a 4-6 percent sodium hydroxide and 2-4 percent EDTA. This was again followed by four water rinses. These
10 valves were treated for about three minutes in the first bath and five minutes in each subsequent bath. The valves were subjected to heat, sonics, and agitation during this primary bath treatment. A 1 percent solution of Cobratech® 45I (45 percent benzotriazoles) was substituted for the final water rinse for three valves. All of the valves were then dried.

15 The valves were all leach tested using the ANSI/NSF 61 Section 8 Leach Test Protocol. The test results were then compared to those from untreated parts, as well as parts that were treated without azoles. A group of valves were also sent to Underwriter Laboratories for confirmation testing, as well.

Test results are shown below in Table 8.

TABLE 8

Azole testing								
	Azoles testing				Non-Azoles Treatment		Untreated	
	FMB Avg. Normalized Results (ppb)		UL Avg. Normalized Results (ppb)		FMB Avg. Normalized Results (ppb)		FMB Avg. Normalized Results (ppb)	
Part Number	pH 5	pH 10	pH 5	pH 10	pH 5	pH 10	pH 5	pH 10
2" Ball Valve	na	0.00	na	na	1.86	14.2	na	45.9
2" Ball Valve	0.83	0.06	1.46	2.45	1.15	2.25	na	39.5
2" Check Valve	0.03	2.10	na	na	1.47	2.08	na	28.81

As seen from this data, parts that included the azoles consistently leach less lead than those that were treated without the azoles.

Based upon these tests, it is determined that it was possible to treat brass articles so as to remove lead therefrom, to the extent that the brass articles would pass the lead leach test target of 5 ppb (normalized) lead.

Commonly used aromatic azoles are: mercaptobezothiazole, benzotriazoles, and tolytriazole. For example, the Cobratech® 45I solution is composed of about 45 percent benzotriazoles and about 55 percent isopropyl alcohol. As demonstrated in Example 6, the azoles decrease the lead leaching when compared to processes without azoles.

The majority of brass parts tested during the course of the present invention passed leach tests for lead when at least 79 mg lead were removed per pound of part treated. The two-inch check valve was the only brass part that did not follow this trend. The two-inch check valve was one of the larger parts tested. In addition, the two-

inch check valve had a sizable amount of surface that is unmachined. It was determined that machined surfaces of brass parts may be more susceptible to treatment than non-machined surfaces. Illustratively, the valves could be rotated in order to better expose all of the surface areas. Alternatively, the treatment baths could be agitated or flowed in
5 order to better reach all surface areas and introduce fresh bath to the surfaces.

Although the present invention has been described with reference to particular means, materials and embodiments, from the foregoing description, one skilled in the art can easily ascertain the essential characteristics of the present invention and various changes and modifications may be made to adapt the various uses and
10 characteristics without departing from the spirit and scope of the present invention as described by the claims which follow.